

Ship July 31

Work Order ID 134847

July 22, 2015 10:27:12 AM

D 4840-041
B 134847

134847

Page 1

Item ID: D4840-041

Revision ID:

Item Name: Upper Cutter Assembly

Start Date: 7/22/2015 Start Qty: 1.00

Required Date: 7/31/2015 Req'd Qty: 1.00

Reference:

REV. A

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 15-7-22

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4840	REV A

110 Pick Kit 0.00

110

Packaging Memo 0.00

Packaging

120 0.00

120

Small Fab Memo 0.00

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces.

A/R LOCTITE 598: M130311

130 QC5- Inspect part completeness to step on W/O 0.00

130

QC Memo 0.00

Quality Control

DAS
38
9-89

JUL 27 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 134847

134847

Page 2

July 22, 2015 10:27:12 AM

Item ID: D4840-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Upper Cutter Assembly
 Start Date: 7/22/2015 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/31/2015 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: _____	0.00							
140									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

1 JUL 28 2015

15/7/28

AB-7-24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

July 22, 2015 10:27:29 AM

Page 1

Work Order ID: 134847

134847

Parent Item: D4840-041

D4840-041

Parent Item Name: Upper Cutter Assembly

Start Date: 7/22/2015

Required Date: 7/31/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.04.29 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D4823-1 Upper Cutter Deflector		Manufactured	No				Each	7.0000	**	1		15/07/28	DAS 36 9-89
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				MF			7						
					105011		4						
					109244		3						
D4824-1 Upper Cutter Mount		Manufactured	No				Each	2.0000	**	1		15/07/28	DAS 36 9-89
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				MF			2						
					109245		2						
D4838-2 Upper Cutter Body, RH		Manufactured	No				Each	2.0000	**	1		15/07/28	DAS 36 9-89
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				MF			2						
					100677		1						
					109247		1						
D4838-1 Upper Cutter Body, LH		Manufactured	No				Each	0.0000	**	1		15/07/28	DAS 36 9-89
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				MF			1						
					100677		1						
					109247		1						

0:109246

Picklist Print

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Work Order ID: 134847

134847

Parent Item: D4840-041

D4840-041

Parent Item Name: Upper Cutter Assembly

Start Date: 7/22/2015

Required Date: 7/31/2015

Start Qty: 1.00

Required Qty: 1.00

D4839-1 Manufactured No

Each 10.0000 2

DAS
36
9-89

D4839-1

Blade

**

15/07/28

Location

Loc Qty

Loc Code

MF

10

133453

2

134649

8

MS27039-08-19

Purchased No

Each 470.0000

14

DAS
36
9-89

MS27039-08-19

Screw

**

15/07/27

Location

Loc Qty

Loc Code

ST273A

438

m131317

438

ST281

32

m127904

3

m131264

29

NAS1149FN832P

Purchased No

Each 3,097.000

28

DAS
36
9-89

NAS1149FN832P

Washer

**

15/07/27

Location

Loc Qty

Loc Code

ST260a

1704

125268

1704

st268

1393

125268

472

M130388

921

20

Picklist Print

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Work Order ID: 134847

134847

Parent Item: D4840-041

D4840-041

Parent Item Name: Upper Cutter Assembly

Start Date: 7/22/2015

Required Date: 7/31/2015

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

Each

860.0000

14

MS21042I 08

DAS
36
9-89

Nut

15/07/27

Location

Loc Qty

Loc Code

CA

101

m129682

101

ST260a

435

m131697

435

ST304

324

123900

16

m128401

102

m128429

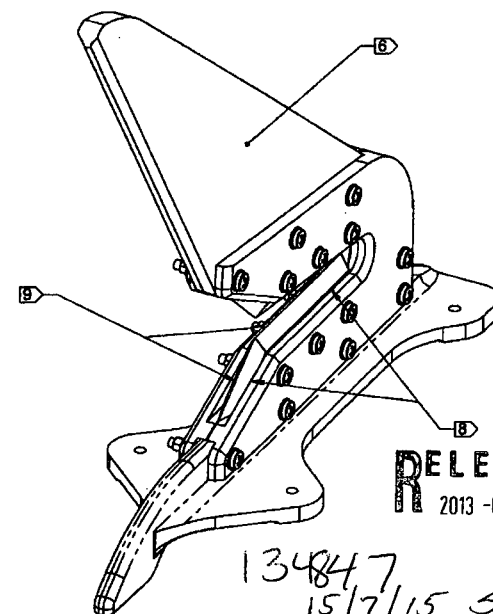
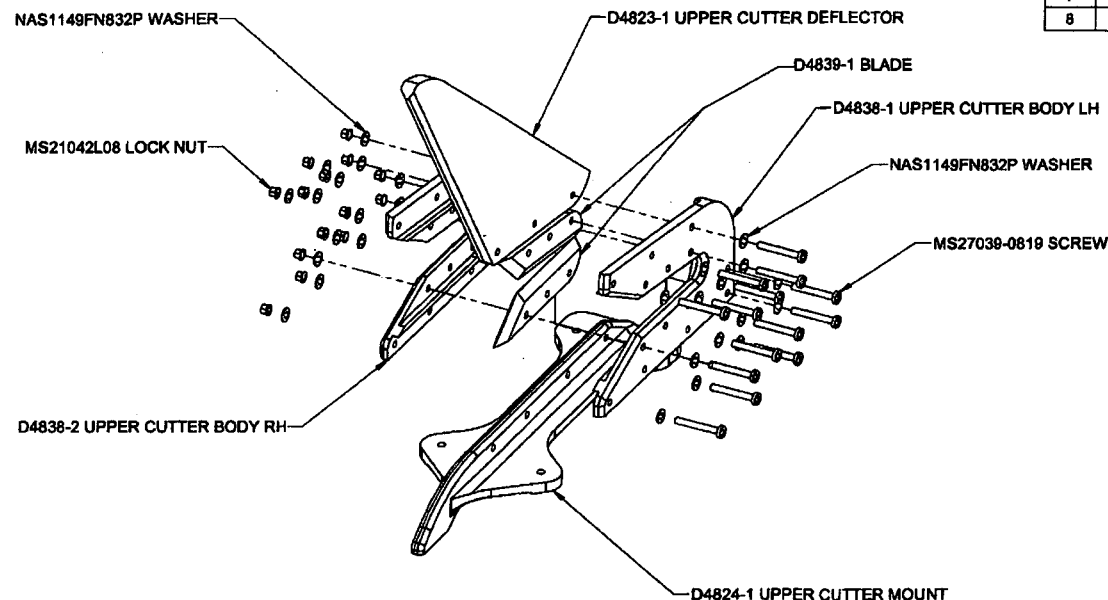
3

m131317

203

14

ITEM	QTY -041	P/N	DESCRIPTION
1	1	D4823-1	UPPER CUTTER DEFLECTOR
2	1	D4824-1	UPPER CUTTER MOUNT
3	1	D4836-1	UPPER CUTTER BODY LH
4	1	D4836-2	UPPER CUTTER BODY RH
5	2	D4839-1	BLADE
6	28	NAS1149FN832P	WASHER (AN960C10)
7	14	MS27039-0819	SCREW
8	14	MS21042L08	LOCKNUT



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4840-041", AGUSTA WESTLAND KIT NUMBER "TBD", REVISION, BATCH NUMBER AND MANUFACTURE DATE, USING AN X-TENSION STAMP, AS PER QSI 044 METHOD 6.2
- 7) WEIGHT: 3.77 LBS (1.63 KGS).
- 8) APPLY RTV SEALANT TO ALL FAYING SURFACES UPON ASSEMBLY
- 9) CUTTING EDGE INTENDED TO BE SHARP. DO NOT BREAK SHARP EDGE.

A NEW RELEASE		DB	13.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.	SH	D4840	SHEET 1 OF 1
APPROVED	162	TITLE	SCALE
DE APPR.	162	UPPER CUTTER ASSY	NTS
DATE	13.05.23	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					